

5/12

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22491
<b>Description:</b> Wearshoe	<b>Part Number:</b>	D2656-37
<b>Drawing:</b> D2656 Rev. C	<b>Qty:</b>	20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	dy	05.02.21	20
2	PG	Issue P/O: <u>200905</u> <b>Email or ship DXF file to vendor</b> Laser Cut per Dwg D2656 flat pattern D2656-37 <b>Material release note required</b>	LL	05.02.22	20
3	RG	Receive and Inspect for transit damage <b>Ensure the material note is attached</b>	cy	05/03/23	20
4	QC6	Inspect dimensions per template D2656-37T1	2	05.04.27	20
5	GB	Deburr if necessary <u>NIA</u>			
6	GB	Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. <b>Identify as D2656-37</b>	2	05.04.27	20
7	QC5	Inspect work to Step 6	2	05/04/27	20
8	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	2	05/4/27	20
9	QC3	Inspect Powder Coat	2	05/04/28	20
10	FP	Identify and Stock	2	05/04/28	20
11	AC	Cost / part: <u>15.62</u>	2	05.04.29	20
12	DC	Close W/O <u>15.62</u> Inspect Level 21	dy	05.05.03	20

Rev	Date	Change	Revised By	Approved
A	97.12.04	New Issue		
B	99.03.16	Re-format	DM	
C	00.11.01	Removed P/O for powder coat - in house process	EC	
D	02.10.25	Re-format	KJ RF	

RELEASED  
06/10/30 RF

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 21, 2005  
07:40 am

Work Order No : 0022491  
Project Name : D2656-37  
Project For : WK512  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2656-37  
Description : Wearplate  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 02-18-05  
Est Finish Date : 03-10-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



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 Glenbrook, South Auckland  
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 (06) 2369 099 Wairarapa  
 Fax: (09) 3758 959 Telex: 24938

## TEST CERTIFICATE

Ref: 9561/12021

CUSTOMER		Wilkinson		SPECIFICATION		ASTMA1008 CS Type A		CERTIFICATE No		TC072790														
CUSTOMER O/N		94-21N-141		PRODUCT		CRA WIDE COIL		PAGE		1 of 1														
MILL O/N		375624		DIMENSIONS		0.833" x 48" x Coil		DATE		29 August 2003														
CHEMICAL COMPOSITION PERCENT																								
PACK NUMBER	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100		x1000		x10000		x100		180°		HRB		( )		(feet)								
R9-413484-08	625796	5	TR	20	8	9	12	18	20	1	5	1	1					Good				44		2467
R9-413485-08	625796	5	TR	20	8	9	12	18	20	1	5	1	1					Good				44		2589
R9-414003-00	625794	5	1	20	8	11	12	18	21	3	6	1	1					Good				49		2644
R9-414004-00	625794	5	1	20	8	11	12	18	21	3	6	1	1					Good				49		2690

20 GA MS

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G L) (A)=200mm (C)=80mm (B)=50mm (D)=5.657 So	PLASTIC STRAIN RATIO (I) (A)=F <sub>U</sub> (C)=45 (B)=F <sub>90</sub> (D)=(F <sub>0.2</sub> +90+2x45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Atish Mishra*  
 QC METALLURGIST

Tue Mar 9 10:19:28 2004

From WILKINSON VAN

